

Date: Tuesday, 5/16/2006 12:26:18 PM  
 User: Linda Lacelle

## Process Sheet

140  
70  
210  
6

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP EXTRUSION  
 Job Number : 27077  
 Estimate Number : 10058  
 P.O. Number : N/A Part Number : D2622120C  
 This Issue : 5/16/2006 S.O. No. : N/A Drawing Number : D2622 REV C1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C1  
 Previous Run : 24563 Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 5/30/2006 Qty: 200 Um: Each  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est. A: 02.11.12 New Issue KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



## Comment: PURCHASING

Issue P/O: 1268

- U 06-05-16 200
- a) Extrude as per Dwg D2622 Rev. C
  - b) Material: 6061-T6 (QQ-A-200/8)
  - c) Minimum yield tensile strength = 35 ksi
  - d) Minimum ultimate tensile strength = 38 ksi
  - e) Minimum elongation = 8%
  - f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
  - h) To be packed per DSK 066
  - i) Pull test to ASTM standard B221 required.
  - j) Material certification is required

2.0 D2622120CP Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 120.0000 Each(s)  
 Extrusion

3.0 PACKAGING 1 PACKAGING RESOURCE #1



## Comment: PACKAGING RESOURCE #1

- 216
- Receive & Inspect For Transit Damage
  - Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



## Comment: DIMENSIONAL CHECK

- AP 06-05-24 200  
216  
24.46
- Inspect dimension per Dwg D2622
  - Check Pull test per Dwg D2622 for compliance page attached
  - Check hardness with Webster tester

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: PD

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: 06/03/25

Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 27077

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA - Yellowbuggies

ml 06 05 24 (216)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

c/Lo

DD 06/05/05 (216)

Job Completion

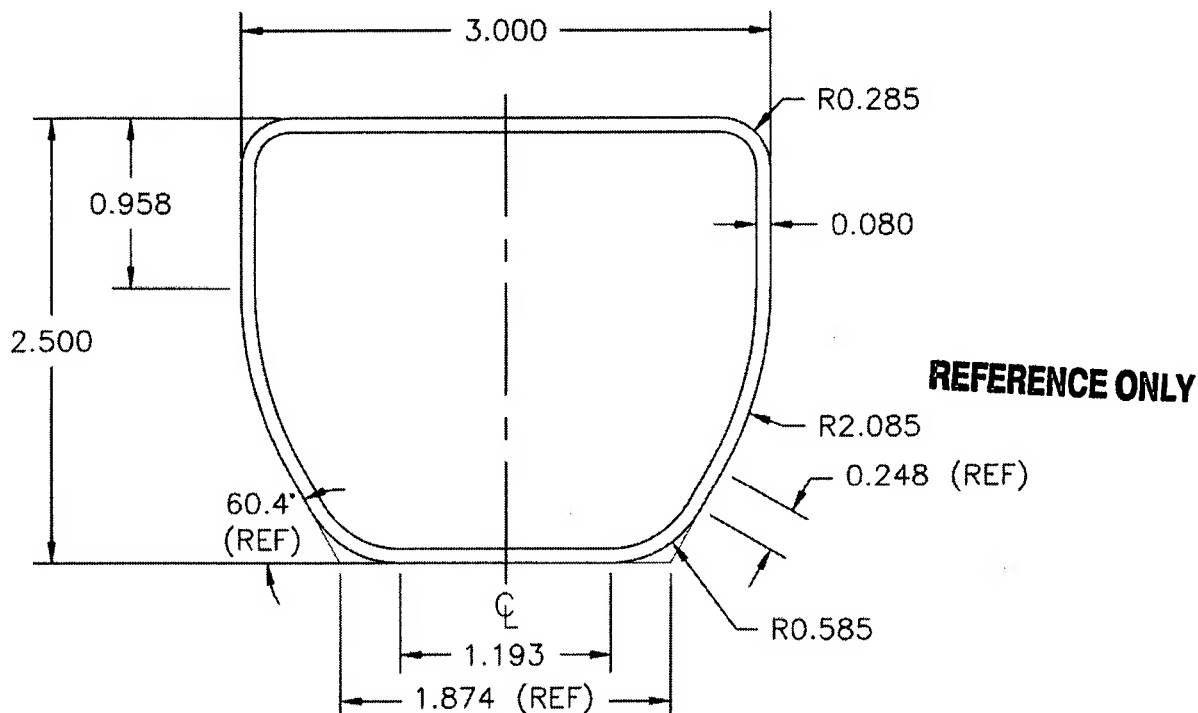


c/Lo 06/05/05



DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	GP 02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED  
02.09.11 H



#### D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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# CERTIFICATE OF COMPLIANCE

**BON L CANADA INC**

500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9

Cert Date	Cert No	Sales Order	Page
05/23/06	139838	22760	1
Cust PO	B/L No	Lot	Date
1268	00304928	22760010	5/23/06

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	938 KGS		
Net Qty	892 KG	207 PC	631 M 4 PKG

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

## Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	325.6 / 47.2	292.4 / 42.4	10.3	.0	93

## Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.67	.28	.30	.04	.92	.05	.000	.07	.000	.009	.02	.000	.00
.00	.00	.00	.00	.00	.00	.000	.00	.000	.000	.00	.000	.00
.00	.00	.00	.00	.00	.00	.000	.00	.000	.000	.00	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada

*[Signature]*  
0605-24